






Work Order ID 48670A

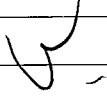
Friday, June 26, 2009 9:20:31 AM



Page 1

Item ID: D412-694-01 Accept  Setup Start 
Revision ID: C1 Stop 
Item Name: Door Assembly
Start Date: 7/15/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 8/3/2009 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-694	Rev C1								

100



DC

Document Control

✓ DOCUMENT CONTROL

Memo

Issue red decal labels for D412-694-01

0.00

0.00

CHG005

110



Small Fab

Small Fab


✓ COMPOSITE ASSEMBLY

Memo

D412-694-01 Drill Process □ 1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P). □ 2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Tra

0.00

0.00

RT 09-10-03
 0910 03

120



Small Fab

Small Fab

(PTO)


✓ COMPOSITE ASSEMBLY

Memo

1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q). □ 2- Sand flush excess Hysol around the insert on both doors.


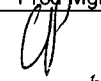
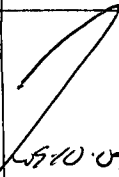

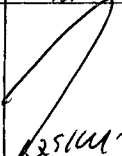
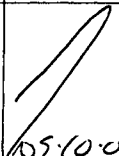
0.00

0.00

RT 09-10-03
 0910 03

EA 934 A/B M110970
M112099

(PTO)

W/O: 48670A		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.10.06	120	DUE TO LACK OF POTTING COMPOUND SUBSTITUTE QTY(6) 80-05-2-8 INSERTS w/ Qty(6) ALS4-1032-130 B/N <u>M111779</u> & RTV 732 B/N <u>M112832</u> OK per DS email attached		09/10/06		 09.10.06 pe QSI 042	 09.10.07	
09.10.07	160	Qty 4 MS24694-S6 m100993 screws used for extra length when shimming the brackets for installation.		09/10/07	2 +2 ↓	 09.10.07	 09.10.07	

Part No: D412-694-01 PAR #: _____ Fault Category: Prod - Small Pts NCR: Yes ☒ No ☐ DQA: 2 Date: 09.10.14
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 48670A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.10.07	160	Qty 2 MS24694-S6 screws were damaged from the screw driver upon inst- allation. R.C. process	<i>[Signature]</i> 09.10.07	Screws replaced Qty 2 m100993 (see above)	<i>[Signature]</i> 09/10/07	<i>[Signature]</i> 09.10.07	<i>[Signature]</i> 09.10.07	<i>[Signature]</i> 09.10.07
09.10.07	160	One D3162-043 Scraped	<i>[Signature]</i> 09.10.07	Replace B36949	<i>[Signature]</i> 09.10.07	<i>[Signature]</i> 09.10.07	<i>[Signature]</i> 09.10.07	<i>[Signature]</i> 09.10.07

NOTE: Date & initial all entries

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Item ID: D412-694-01

Accept

Setup Start

Revision ID: C1

Stop

Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

✓ QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect that inserts are flush with the surface.

05-10-05

140

✓ COMPOSITE ASSEMBLY

0.00



Small Fab

Memo

0.00

Small Fab

1. Apply Primer filler and reducer around the inserts on both doors. □ A/R

11045 Primer Filler

Batch: 1112704 □ A/R

12375S Reducer

Batch: 112704

09 10 05

150

✓ QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

09 10 07

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Item ID: D412-694-01

Accept

Setup Start

Revision ID: C1

Stop

Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Small Fab

Small Fab

/COMPOSITE ASSEMBLY

0.00

Memo

0.00

D412-694-01 Assembly Process □ 1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes. □ Note: Start installation window side. Wait to fix D316

091007
09-10-07

170



QC

Quality Control

/QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1
091007

180



Small Fab

Small Fab

/COMPOSITE ASSEMBLY

0.00

Memo

0.00

D412-694-01 Assembly Process (Continued) □ 1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N). □ Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door. □ 2- Install

091007
09-10-07

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Item ID: D412-694-01

Accept

Setup Start

Revision ID: C1

Stop

Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:


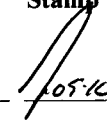




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	✓ QC5- Inspect part completeness to step on W/O	0.00				1			 05/10/07
QC Quality Control	Memo Install door on mock up helicopter to insure proper fit and function	0.00							
200 	COMPOSITE ASSEMBLY	0.00							 09/10/07
Small Fab Small Fab	Memo 1- Finish installing D3163-041 in the door. □ 2- Install red decal before closing cover.	0.00							
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							 09 - 10 07

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Item ID: D412-694-01

Accept

Setup Start

Revision ID: C1

Stop

Item Name: Door Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Identify as per dwg & Stock Location: _____

0.00

48670

u



Packaging

Memo

0.00

Packaging

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07 [Signature]

u 9-10-07

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ NAS43DD3-14 Spacer		Purchased	No			120	Each	0.0000	6.0000	19347		
✓ 80-005-2-8 Insert		Purchased	No	-5		160	Each	0.0000	55.0000	19443	M112830 (52) 9/10/5	
✓ AN525-10R6 Screw		Purchased	No			160	Each	0.0000	12.0000	101203		SP
✓ AN525-10R7 Screw		Purchased	No			160	Each	0.0000	8.0000	112411		SP
✓ AN960JD10L Washer		Purchased	No			160	Each	0.0000	18.0000	109632		SP
✓ AN960JD10LL Washer		Purchased	No			160	Each	0.0000	15.0000	19600		SP
✓ AN960JD416L Washer		Purchased	No			160	Each	0.0000	6.0000	110153		SP
✓ AN960JD8 Washer		Purchased	No			160	Each	0.0000	6.0000	111578		SP
✓ BSP45 Commercial Rivet		Purchased	No			160	Each	0.0000	79.0000	107296		SP

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ BSP46 		Purchased	No			160	Each	0.0000	6.0000			sp
Commercial rivet ✓ CR3212-4-04 		Purchased	No			160	Each	0.0000	16.0000			sp
Cherry Rivet ✓ D3110-5RevC 		Manufactured	No			160	Each	0.0000	1.0000			sp
Handle Assembly ✓ D3115-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			sp
Bracket ✓ D3116-7RevA 		Manufactured	No			160	Each	0.0000	5.6666			sp
Seal ✓ D3116-9RevA 		Manufactured	No			160	f	0.0000	6.4166			sp
Seal ✓ D3121-041RevE 		Manufactured	No	X-3		160	Each	0.0000	3.0000			sp
Bracket Assembly ✓ D3121-043RevE 		Manufactured	No			160	Each	0.0000	1.0000			sp
Bracket Assembly ✓ D3122-1RevC 		Manufactured	No			160	Each	0.0000	1.0000			sp
Lever												

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly



















Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3123-1RevC 		Manufactured	No			160	Each	0.0000	2.0000			
										1053617	SP	
✓ Jam D3124-1RevB 		Manufactured	No			160	Each	0.0000	1.0000			
										1053617	SP	
✓ Hook D3124-2RevB 		Manufactured	No			160	Each	0.0000	1.0000			
										1053617	SP	
✓ Hook D3126-1RevA1 		Manufactured	No			160	Each	0.0000	1.0000			
										41429	SP	
Bracket D3126-3RevA1 		Manufactured	No			160	Each	0.0000	1.0000			
										28105	SP	
Bracket D3126-5RevA1 		Manufactured	No			160	Each	0.0000	5.0000			
										36729	SP	
✓ D3132-041RevB 		Manufactured	No			160	Each	0.0000	1.0000			
										1053617	SP	
✓ Rod Weldment D3133-042RevB 		Manufactured	No			160	Each	0.0000	1.0000			
										1053617	SP	
✓ Rod Weldment D3135-041RevD 		Manufactured	No			160	Each	0.0000	1.0000			
										52370SP		✓
Handle Weldment												

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3137-045RevF Bracket Assembly		Manufactured	No	-1		160	Each	0.0000	1.0000	52371		
✓ D3138-1RevC Cover		Manufactured	No			160	Each	0.0000	1.0000	39184	50	
✓ D3139-1RevB Guard		Manufactured	No			160	Each	0.0000	1.0000	24700	50	
✓ D3139-3RevB Guard		Manufactured	No			160	Each	0.0000	1.0000	24700 18863	50	
✓ D3140-05RevF Door		Manufactured	No			160	Each	0.0000	1.0000	52670A		
✓ D3141-1RevA Spring		Manufactured	No			160	Each	0.0000	2.0000	50302		
✓ D3144-109RevC Doubler		Manufactured	No			160	Each	0.0000	1.0000	23145		
✓ D3144-111RevC Doubler		Manufactured	No	-1		160	Each	0.0000	1.0000	B52372		
✓ D3144-13RevC Doubler		Manufactured	No			160	Each	0.0000	1.0000	24723 21911	50	

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly










Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3144-3RevC 		Manufactured	No			160	Each	0.0000	1.0000		1/8/18	SP
Doubler												
✓ D3148-1RevB 		Manufactured	No			160	Each	0.0000	2.0000		10530-17 205783	SP
Clevis												
✓ D3151-041RevC 		Manufactured	No			160	Each	0.0000	1.0000		39/86	SP
Doubler Assembly												
✓ D3152-041RevB 		Manufactured	No			160	Each	0.0000	1.0000		25284	SP
Bracket Assembly												
✓ D3155-041RevD 		Manufactured	No			160	Each	0.0000	1.0000		27178	SP
Bracket Assembly												
✓ D3155-042RevD 		Manufactured	No			160	Each	0.0000	1.0000		24343	SP
Bracket Assembly												
✓ D3156-1RevB 		Manufactured	No			160	Each	0.0000	2.0000		24772	SP
Bracket												
✓ D3162-041RevC 		Manufactured	No			160	Each	0.0000	10.0000		50370	SP
Bracket Assembly												
✓ D3162-043RevC 		Manufactured	No			160	Each	0.0000	1.0000		36949	SP
Bracket Assembly												

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly










Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3162-044RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Bracket Assembly												
① ✓ D3163-041RevD 		Manufactured	No			160	Each	0.0000	1.0000			
Cover Assembly												
✓ D3183-041RevC1 		Manufactured	No			160	Each	0.0000	1.0000			
Bracket Assembly												
✓ D3203-1RevC 		Manufactured	No			160	Each	0.0000	1.0000			
Handle												
✓ D3308-1RevA 		Manufactured	No			160	Each	0.0000	2.0000			
Doubler												
✓ M7885/2-4-3 		Purchased	No			160	Each	0.0000	12.0000			
Rivet												
✓ M7885/3-4-4 		Purchased	No			160	Each	0.0000	14.0000			
Rivets												
✓ MS20392-2C17 		Purchased	No			160	Each	0.0000	2.0000			
Pin												
✓ MS20392-2C9 		Purchased	No			160	Each	0.0000	2.0000			
Pin												

36734 SP
50217 SP
36735 SP
48565 SP
39187 SP
107376 SP
104625 SP
18949 SP
11784 SP
9/9/24 @

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly



















Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS20392-3C21 		Purchased	No			160	Each	0.0000	2.0000	 104856		SP
Pin ✓ MS20426AD3-3 		Purchased	No			160	Each	0.0000	8.0000	 7687		SP
Rivet ✓ MS20426AD4-5 		Purchased	No			160	Each	0.0000	4.0000	 4067		SP
Rivet ✓ MS21042L08 		Purchased	No			160	Each	0.0000	6.0000	 112492		SP
Nut ✓ MS21042L4 		Purchased	No			160	Each	0.0000	4.0000	 1.12314		SP
Nut ✓ MS21072-L3 		Purchased	No			160	Each	0.0000	4.0000	 112492		SP
Nutplate ✓ MS24665-151 		Purchased	No			160	Each	0.0000	6.0000	 14526		SP
Cotter Pin ✓ MS24693-S271 		Purchased	No			160	Each	0.0000	4.0000	 14478		SP
Screw ✓ MS24694-C5 		Purchased	No			160	Each	0.0000	4.0000	 106815		SP
Screw										9/12/24 (1x)		

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Work Order ID: 48670A

Parent Item: D412-694-01RevC1

Parent Item Name: Door Assembly

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

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Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS24694-S5 Screw		Purchased	No			160	Each	0.0000	6.0000	18949	SP	
✓ MS24694-S50 Screw		Purchased	No			160	Each	0.0000	18.0000	112195	SP	
✓ MS24694-S98 Screw		Purchased	No			160	Each	0.0000	4.0000	111776	SP	
✓ MS27039-1-05 Screw		Purchased	No			160	Each	0.0000	2.0000	3501	SP	
✓ MS27039-1-06 Screw		Purchased	No			160	Each	0.0000	14.0000	164289	SP	
✓ MS27039-1-08 Screw		Purchased	No			160	Each	0.0000	13.0000	110552	SP	
✓ MS35275-233 Screw		Purchased	No			160	Each	0.0000	2.0000	11822	SP	
✓ MS35649-264 Screw		Purchased	No			160	Each	0.0000	2.0000	11822	SP	
✓ MS35650-3252 Nut		Purchased	No			160	Each	0.0000	2.0000	118372	SP	

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PTU and page

MS24694-S6

100993

QTY \$

77 891005

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Work Order ID: 48670A



Parent Item: D412-694-01RevC1



Parent Item Name: Door Assembly





Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS51859-7 		Purchased	No			160	Each	0.0000	2.0000 	011193	5/1	
✓ Washer NAS43DD3-10 		Purchased	No			160	Each	0.0000	7.0000 	19347	5/1	
Spacer												

9/9/24 @

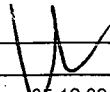
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Shop Packet Print

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Date: Monday, 22/06/2009 11:51:00 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 48670A		
Estimate Number	: 11454		
P.O. Number	:	Part Number	: D41269401
This Issue	: 22/06/2009 S.O. No. :	Drawing Number	: D412-694
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 22/06/2009 Type : SMALL /MED FAB	Drawing Revision	: C1
Previous Run	: 39169A	Material	:
Written By	: 	Due Date	: 10/09/2009 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF : Est Rev: B 06.04.18 New dwg rev. ecn781 EC : Est Rev: C 06.07.11 Revised per B24660 KJ : Est Rev: D 08-08-27 replace QC5 to QC14 seq.7 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 ✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-01 CHG005

2.0 ✓ PG

PURCHASING



Comment: PURCHASING

 ISSUE P.O. 9004 1 X D3140-05 REV.F
 DELASTEK

C209/06/23 ①

3.0 ✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

 RECEIVE AND INSPECT FOR TRANSIT DAMAGE
 ENSURE MATERIAL CERT AND PROCESS SHEET ATTACHED

4.0 ✓ QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 ✓ D314005

Door


 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Door Kit
 Batch

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.10.07	160	Required M 7885-3-4 M 104625 M 520426 ADX-6 M 105144	<i>[Signature]</i>	09.10.07	10 4	<i>[Signature]</i> 09.10.07	<i>[Signature]</i> 09.10.07	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Process Sheet

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Job Number: 48670A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Drill Process

1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P).

Note: D3151-041 orientation in the door.

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).

4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2.

Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.

5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.

9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover.

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Drawing Name: DOOR ASSEMBLY

Job Number: 48670A

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Machine Or Operation:

Description :

7.0



8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

8.0



COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors.

9.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

10.0



COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch:

A/R 12375S

Reducer

Batch:

11.0



QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

12.0



D31105

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

13.0



D31151

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

✓ D31167

Seal



Comment: Qty.: 5.6666 f(s)/Unit Total : 5.6666 f(s)

Seal ZX2054

Batch

15.0

✓ D31169

Seal



Comment: Qty.: 6.4166 f(s)/Unit Total : 6.4166 f(s)

Seal ZX1267

Batch

16.0

✓ D3121041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

17.0

✓ D3121043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

18.0

✓ D31221

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

19.0

✓ D31231

Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

Batch

20.0

✓ D31241

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

✓ D31242

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

22.0

✓ D31261

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

23.0

✓ D31263

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

24.0

✓ D31265

Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Batch

25.0

✓ D3132041

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

26.0

✓ D3133042

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

27.0

✓ D3135041

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch

W/O:		WORK ORDER CHANGES					
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Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

✓ D3137045

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET ASSEMBLY

Batch

29.0

✓ D31381

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

30.0

✓ D31391

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

31.0

✓ D31393

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

32.0

✓ D31411

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring #204-032-734-001

Batch

33.0

✓ D31443

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

34.0

✓ D314413

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

✓ D3144109

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

36.0

✓ D3144111

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

37.0

✓ D31481

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch

38.0

✓ D3151041

Doubler Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler Assembly

Batch

39.0

✓ D3152041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

40.0

✓ D3155041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

41.0

✓ D3155042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 48670A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

✓ D31561

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch

43.0

✓ D3162041

Bracket Assembly



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bracket Assembly

Batch

44.0

✓ D3162043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

45.0

✓ D3162044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

46.0

✓ D3163041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

Batch

47.0

✓ D3183041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

48.0

✓ D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

✓ D33081

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

Batch

50.0

✓ AN52510R6

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

51.0

✓ AN52510R7

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Batch

52.0

✓ AN960JD8

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

53.0

✓ AN960JD10L

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

54.0

✓ AN960JD10LL

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

55.0

✓ AN960JD416L

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

✓ BSP45

Commercial Rivet



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)
Commercial Rivet

Batch

57.0

✓ BSP46

Commercial rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Commercial rivet

Batch

58.0

✓ M7885243

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Rivet

Batch

59.0

✓ M7885344

Rivets



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Rivets

Batch

60.0

✓ MS203922C9

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pin

Batch

61.0

✓ MS203922C17

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pin

Batch

62.0

✓ MS203923C21

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pin
Batch

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

63.0



MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

64.0



MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

65.0



CR3212404

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch

66.0



MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

67.0



MS21042L08

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch

68.0



MS21072L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nutplate

Batch

69.0



MS24665151

Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Batch

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

70.0



MS24693S271

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

71.0



MS24694C5

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

72.0



MS24694S5

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

73.0



MS24694S50

Screw



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch

74.0



MS24694S98

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

75.0



MS27039105

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

76.0



MS27039106

Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

77.0

✓ MS27039108

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch

78.0

✓ MS35275233

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

79.0

✓ MS35649264

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

80.0

✓ MS356503252

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

81.0

✓ MS518597

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

82.0

✓ NAS43DD310

Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

83.0

✓ NAS43DD314

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

84.0



COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

85.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

86.0



COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

4- Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 11:51:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48670A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

A/R RTV732 Clear Batch: _____ Expiry Date: _____

7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

87.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function

88.0

✓

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Finish installing D3163-041 in the door.

2- Install red decal before closing cover.

89.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

90.0

✓

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

91.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED Jdh	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13 #

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED Jh	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
06.11.13 #

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

F

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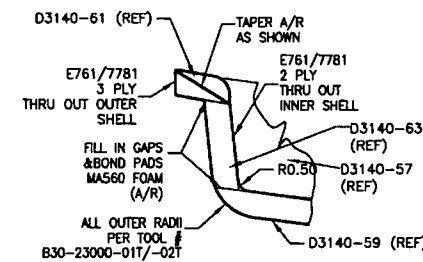
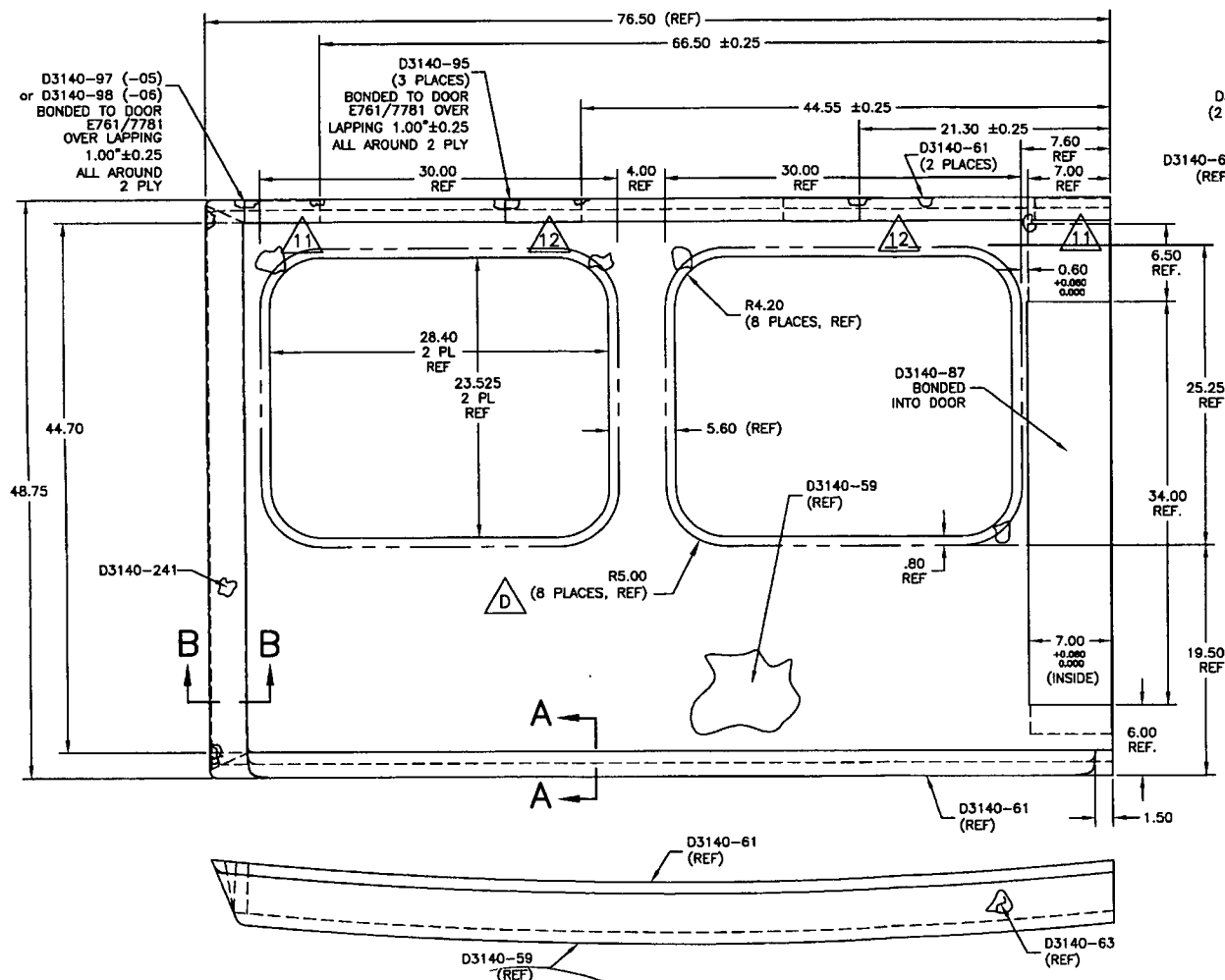
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

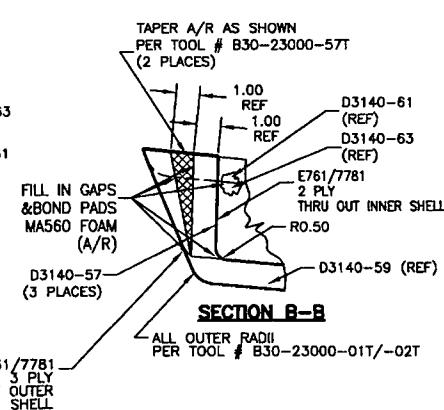
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
06.11.13



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

1 2 3

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DESIGN #	DRAWN BY CB	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 3 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

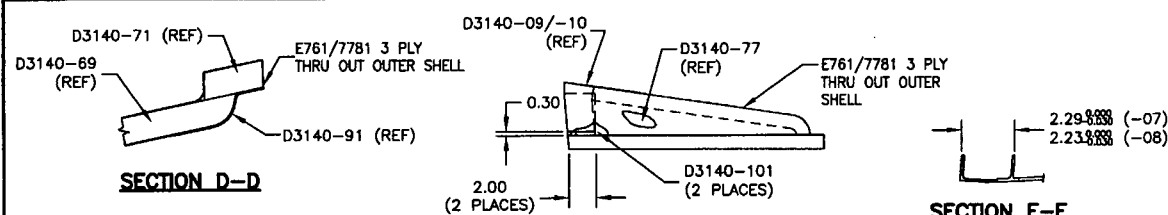
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

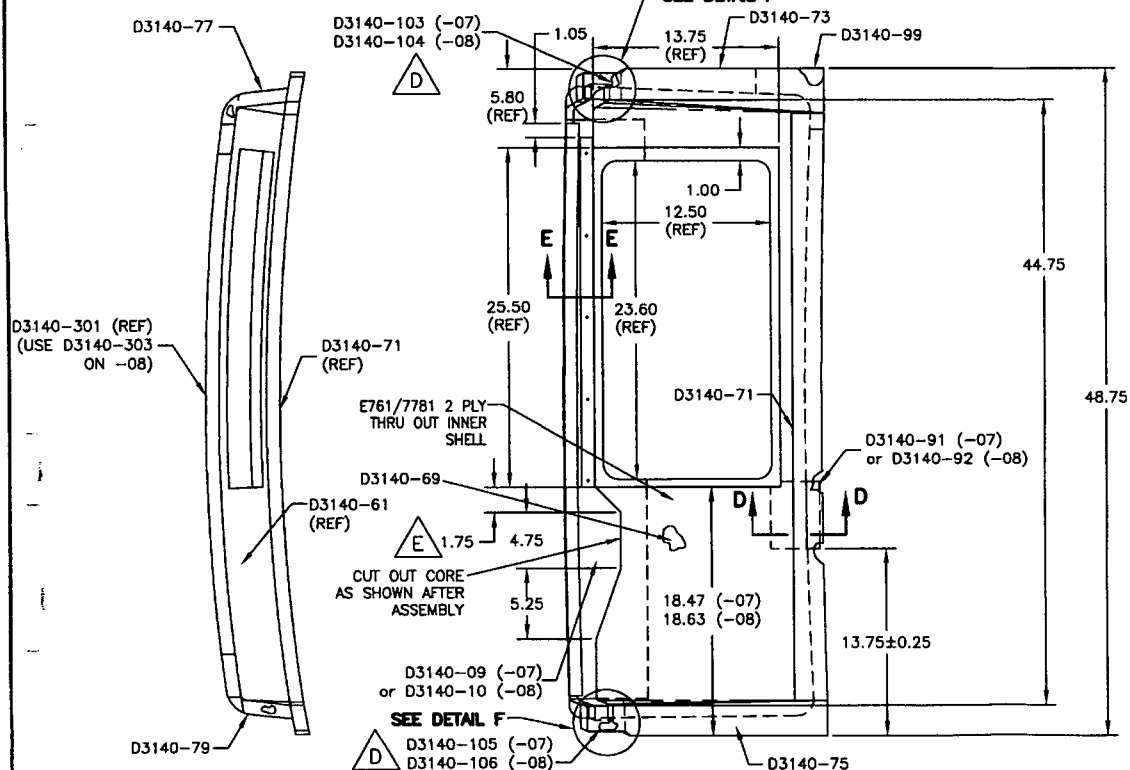
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



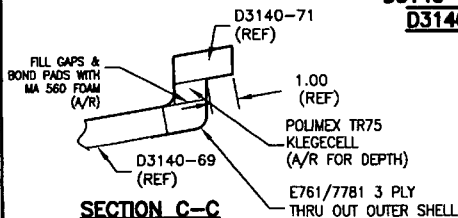
SECTION E-E



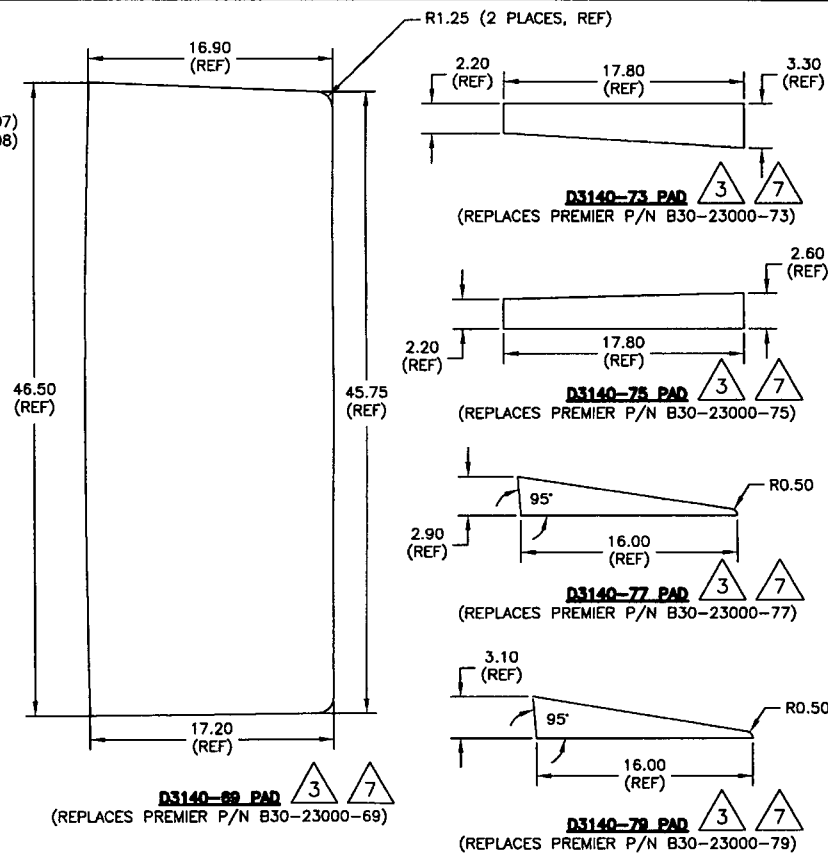
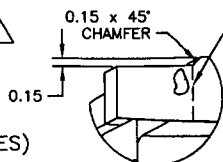
D3140-07 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-07)

D3140-08 (OPPOSITE, REPLACES PREMIER P/N B30-23000-08)

(WINDOW TO BE LOCATED BY TOOL B30-23000-03T/-04T)



DETAIL F
(TYPICAL 2 PLACES)



RELEASED

06.11.13

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. F
DATE	06.10.06	D3140	SHEET 4 OF 7
		TITLE	SCALE
		DOOR	NTS

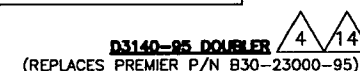
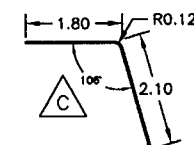
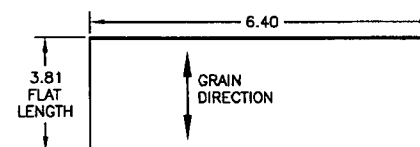
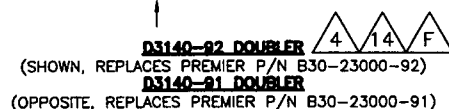
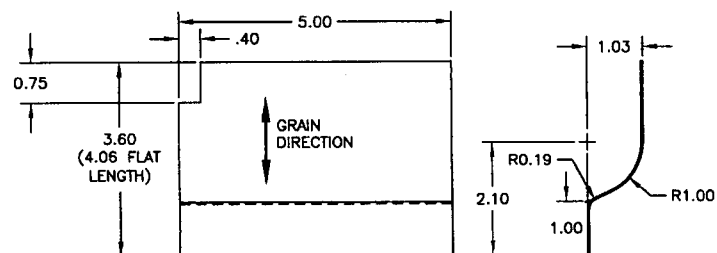
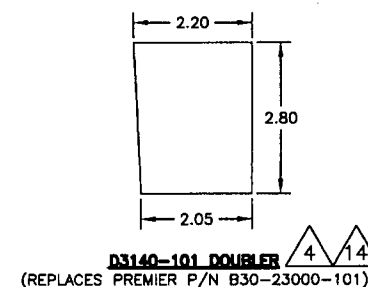
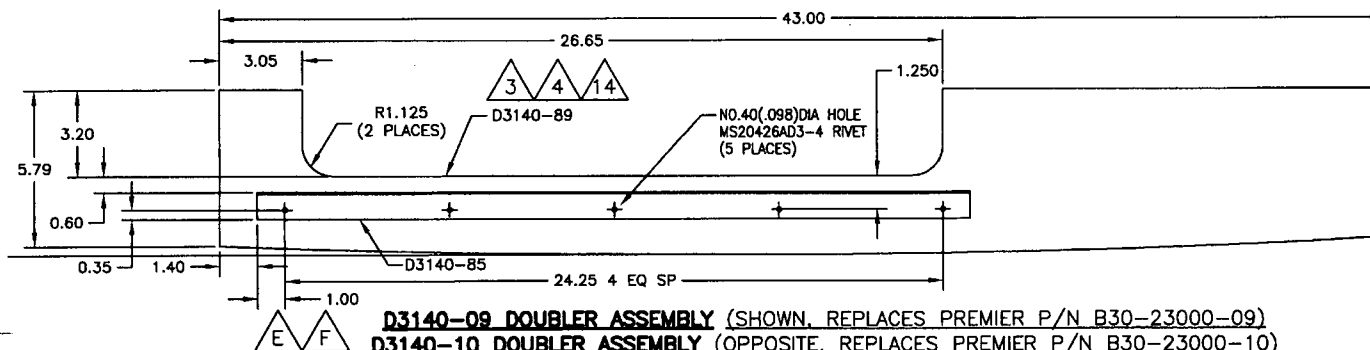
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

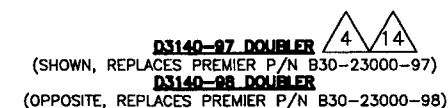
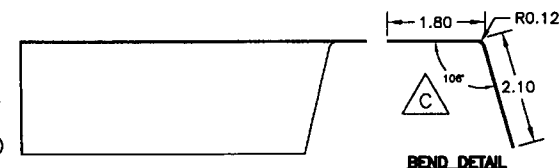
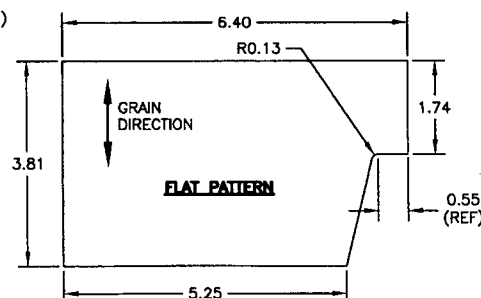
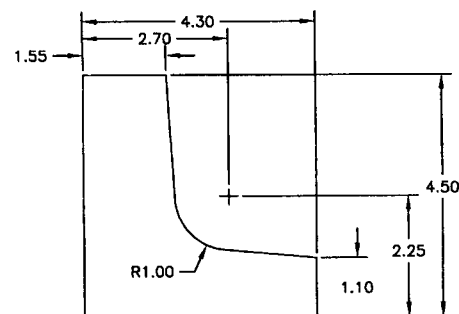
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

06.11.13



BEND DETAIL

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CHECKED	APPROVED	DRAWING NO.		REV. F	
DATE	06.10.06	D3140		SHEET 5 OF 7	
		TITLE		SCALE	
		DOOR		NTS	

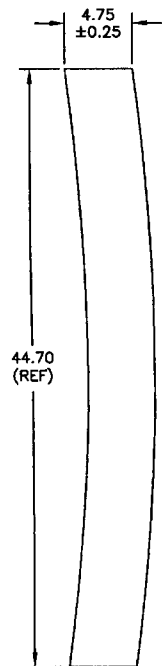
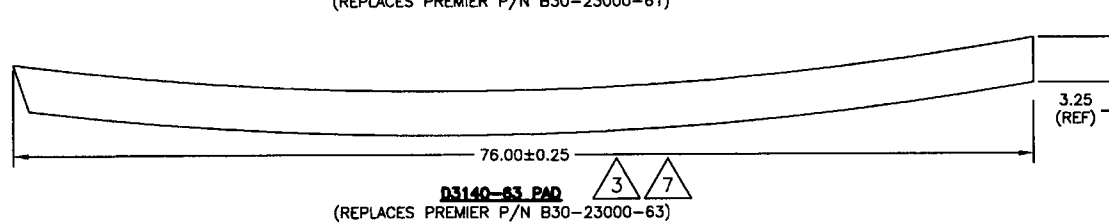
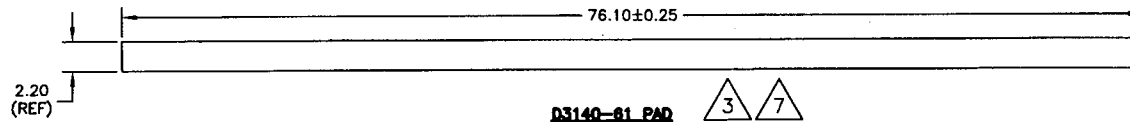
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

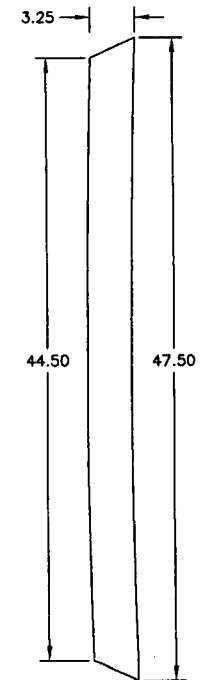
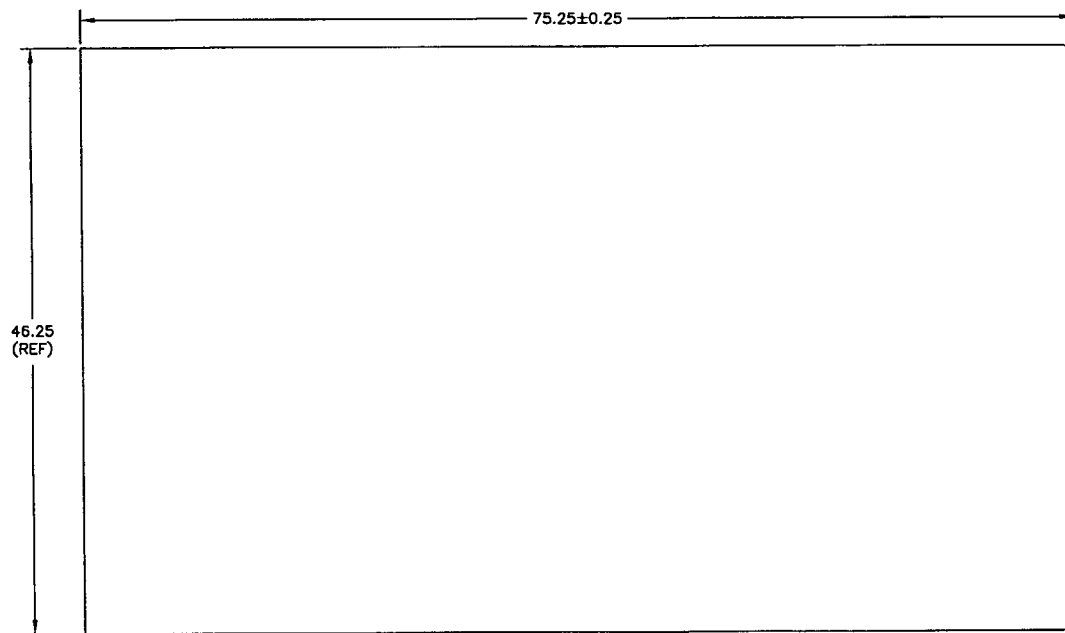
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)

$\triangle 3 \triangle 7$



D3140-241 DOUBLER $\triangle 5 \triangle 14$
(REPLACES PREMIER P/N B30-23000-241)

RELEASED
06.11.13

R1.00
(2 PLACES, REF)

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DESIGN 4	DRAWN BY CB	DART DART AEROSPACE LTD. HAMMERSBURY, OXFORD, CANADA
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3140
DATE 06.10.06	TITLE DOOR	REV. F SHEET 7 OF 7 SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D012-694-01	DOOR ASSEMBLY
	X			D012-694-02	DOOR ASSEMBLY
		X		D012-694-03	DOOR ASSEMBLY
			X	D012-694-04	DOOR ASSEMBLY
		1	1	D0110-1	ESCUTOHEON
		1	1	D0110-3	HANDLE
1	1			D0110-6	HANDLE ASSEMBLY
		1	1	D0111-041	PLATE ASSEMBLY
		2	2	D0112-1	GUIDE
		1	1	D0113-1	SPRING
		1	1	D0114-1	PIVOT
1	1			D0115-1	BRACKET
		1	1	D0116-11-0180	SEAL
		1	1	D0116-5-0880	SEAL
1	1			D0116-7-0880	SEAL
1	1			D0116-9-0770	SEAL
		1		D0119-041	COVER ASSEMBLY
		1		D0119-042	COVER ASSEMBLY
		1		D0120-1	COVER
		1		D0120-2	COVER
		1		D0120-3	COVER
		1		D0120-4	COVER
3	3			D0121-041	BRACKET ASSEMBLY (ROLLER)
1				D0121-043	BRACKET ASSEMBLY (ROLLER)
1	1			D0121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D0122-1	LEVER
2	2			D0123-1	CAM
1	1			D0124-1	HOOK
1	1			D0124-2	HOOK
		1	1	D0125-1	LEVER
		1	1	D0125-3	LEVER
		1	1	D0125-5	LEVER
		1	1	D0125-7	LEVER
1	1			D0126-1	BRACKET (SLIDER)
1	1			D0126-3	BRACKET (SLIDER)
5	5			D0126-5	BRACKET (SLIDER)
1	1			D0127-1	SPACER
		1	1	D0128-1	SHIM
		2	2	D0129-1	LEVER
		2	2	D0130-1	CLEVIS BASE
		1	1	D0131-1	STOP
1				D0132-041	ROD WELDMENT
	1			D0132-042	ROD WELDMENT
	1			D0133-041	ROD WELDMENT
1				D0133-042	ROD WELDMENT
		1	1	D0134-1	ROD
		1	1	D0134-3	ROD
1	1			D0135-041	HANDLE WELDMENT
1	1			D0137-045	BRACKET ASSEMBLY
1				D0138-1	COVER
		1		D0138-2	COVER
1	1			D0139-1	GUARD
1				D0139-3	GUARD
	1			D0139-4	GUARD
1				D0140-05	DOOR
	1			D0140-06	DOOR
		1		D0140-07	DOOR
		1		D0140-08	DOOR
2	2			D0141-1	SPRING
		1	1	D0143-1	CLEVIS
		3	3	D0143-3	CLEVIS
		1		D0144-1	DOUBLER
1				D0144-3	DOUBLER
		1		D0144-105	DOUBLER
		1		D0144-107	DOUBLER
1				D0144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D0144-111	DOUBLER
	1			D0144-115	DOUBLER
		1		D0144-117	DOUBLER
		1		D0144-121	DOUBLER
		1		D0144-119	DOUBLER
		1		D0144-123	DOUBLER
1	1			D0144-13	DOUBLER
		1		D0145-1	HINGE BRACKET
		1		D0145-2	HINGE BRACKET
		1		D0145-3	HINGE BRACKET
		1		D0145-2	HINGE BRACKET
		2	2	D0147-1	PIN
2	2			D0148-1	CLEVIS
		2	2	D0149-1	STRIKER PLATE
		2	2	D0150-1	GUIDE
1	1			D0151-041	DOUBLER ASSEMBLY
1				D0152-041	BRACKET ASSEMBLY
	1			D0152-042	BRACKET ASSEMBLY
		1	1	D0154-1	KEY
1	1			D0155-041	BRACKET ASSEMBLY
1	1			D0155-042	BRACKET ASSEMBLY
2	2			D0156-1	BRACKET
		2	2	D0157-1	SPACER
		3	3	D0159-041	BRACKET ASSEMBLY
		1		D0159-043	BRACKET ASSEMBLY
		1		D0159-044	BRACKET ASSEMBLY
10	10			D0162-041	BRACKET ASSEMBLY
1		1		D0162-043	BRACKET ASSEMBLY
1		1		D0162-044	BRACKET ASSEMBLY
1				D0163-041	COVER ASSEMBLY
	1			D0163-042	COVER ASSEMBLY
1				D0180-041	BRACKET ASSEMBLY (ROLLER)
1	1			D0183-042	BRACKET ASSEMBLY (ROLLER)
1	1			D0303-1	HANDLE ASSEMBLY
2	2			D0308-1	DOUBLER
55	55	21	21	80-005-28	INSERT (OR SL0052-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN660-D10	WASHER
18	18	4	4	AN660-D10L	WASHER
13	13	32	32	AN660-D10LL	WASHER
6	6			AN660-D11L	WASHER
		4	4	AN660-D1L	WASHER
6	6			AN660-D18	WASHER
		2	2	AN660-D1L	WASHER
		2	2	AN660-D1LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FW10-032	WASHER
		6	6	FW10-032	WASHER
12	12			M7885-24	RIVET (OR CR3213-4-3)
		3	3	M7885-34	RIVET (OR CR3212-4-3)
		2	2	M520392-1C11	PIN
		7	7	M520392-2C15	PIN
2	2			M520392-2C17	PIN
2	2	2	2	M520392-2C9	PIN
2	2			M520392-3C21	PIN
8	8			M52065AD3	RIVET
12	12			M7885/3-4	Rivet
8	8			M520426AD4	Rivet

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
28	28			M52065AD4	RIVET
		6	6	M521042L05	NUT
6	6	2	2	M521042L08	NUT
		5	5	M521042L3	NUT
4	4			M521042L4	NUT
4	4			M521072L3	NUT PLATE
6	6	9	9	M524865-151	COTTER PIN
4	4			M524863-S271	SCREW
		2	2	M524864-C4	SCREW
4	4			M524864-C5	SCREW
6	6			M524864-S5	SCREW
18	18			M524864-S50	SCREW
		4	4	M524864-S55	SCREW
		2	2	M524864-S53	SCREW
		4	4	M524864-S50	SCREW
4	4			M524864-S58	SCREW
		2	2	M525261-F6	CLAMP
2	2	2	2	M527039-1-05	SCREW
14	14	12	12	M527039-1-06	SCREW
13	13	6	6	M527039-1-08	SCREW
		2	2	M535205-231	SCREW
2	2			M535275-233	SCREW
2	2			M535540-254	NUT
		4	4	M535550-305T	NUT
2	2			M535550-3252	NUT
2	2	3	3	M551869-7	WASHER
		4	4	NAS1169-10L	WASHER
		14	14	NAS306-6-8P	SCREW
		15	15	NAS301BBP	WASHER
7	7			NAS4003-10	SPACER
6	6			NAS4003-14	SPACER
		2	2	NAS4003-40	SPACER

GENERAL NOTES

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D0124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D0125-1 LEVER (REF) TO CLEAR THE D0130-1 CLEVIS BASE (REF, 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JGS. E30-23000-01; D0144-T1/T2-T3; D0180-3; D0162-041/T1 (FOR -01 DOOR ASSY); E30-23000-02; D0144-T7/T8-T9; D0180-4; D0162-041/T2 (FOR -02 DOOR ASSY); D0144-T4/T5-T6; D0119-041/T1; D0112-T1/T2 (FOR -03 DOOR ASSY); D0144-T10/T11-T12; D0119-042/T1; D0112-T1/T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER PART QIS 006. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER PART QIS 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D012-694-01-02-03-04 DOOR ASSEMBLIES USING D0728-1 DECALS.

C1	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	TITLE DOOR ASSEMBLY
		SCALE NTS

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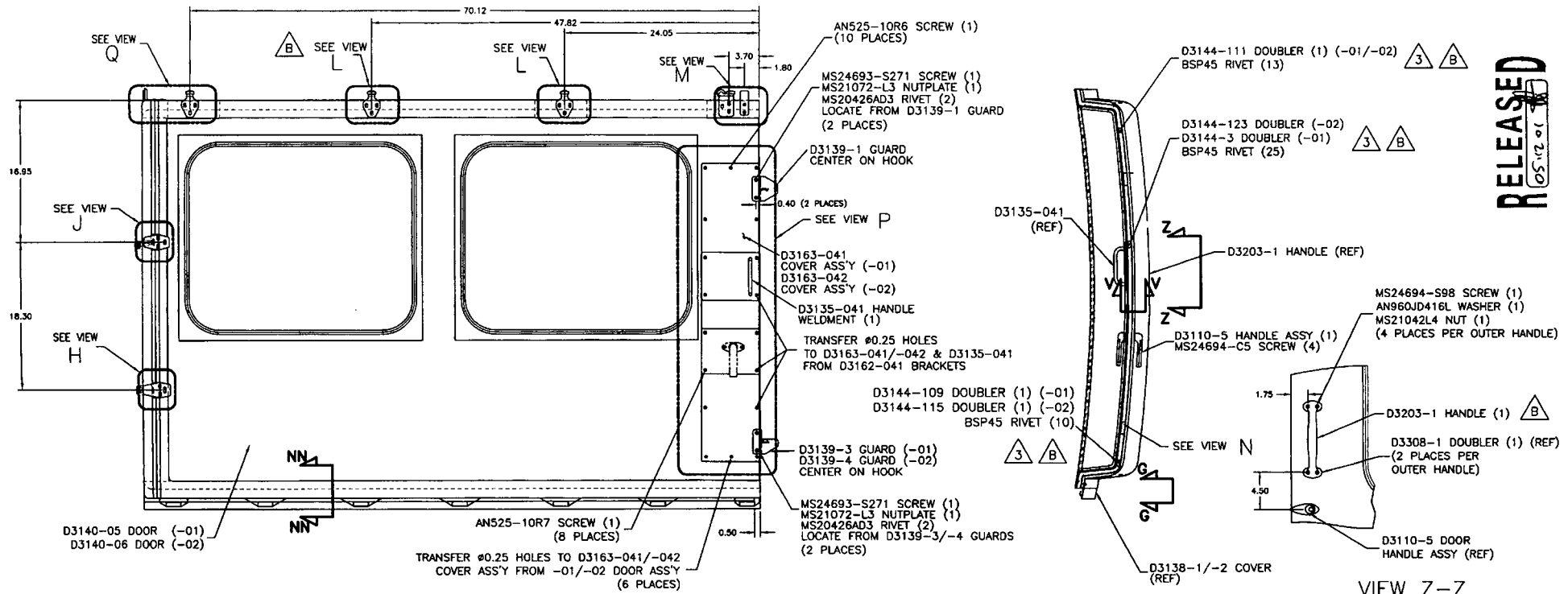
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HAMKESBURY, ONTARIO, CANADA

DRAWING NO. D412-694
SHEET 1 OF 6
SCALE NTS

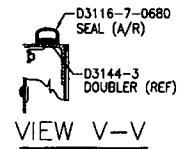
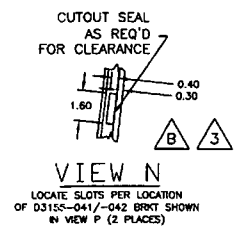
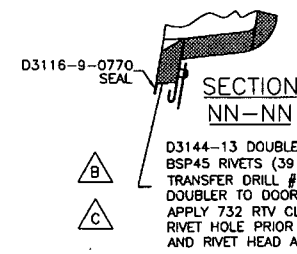
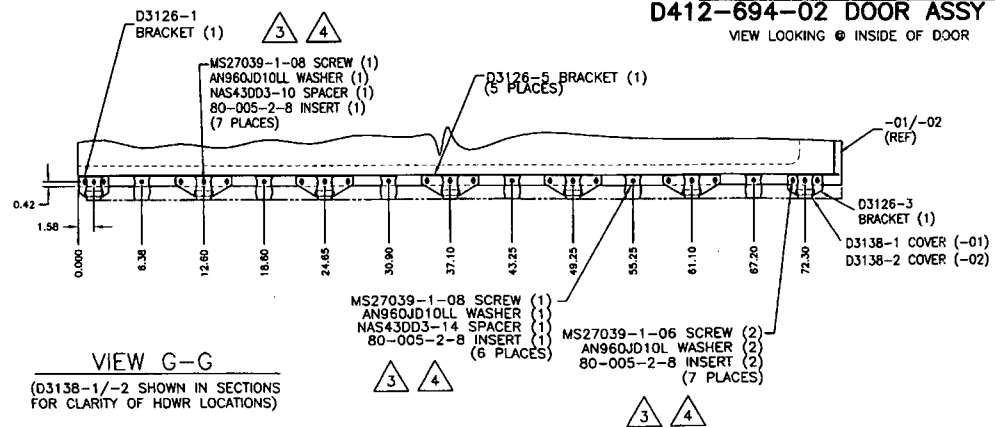
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05.12.01-#

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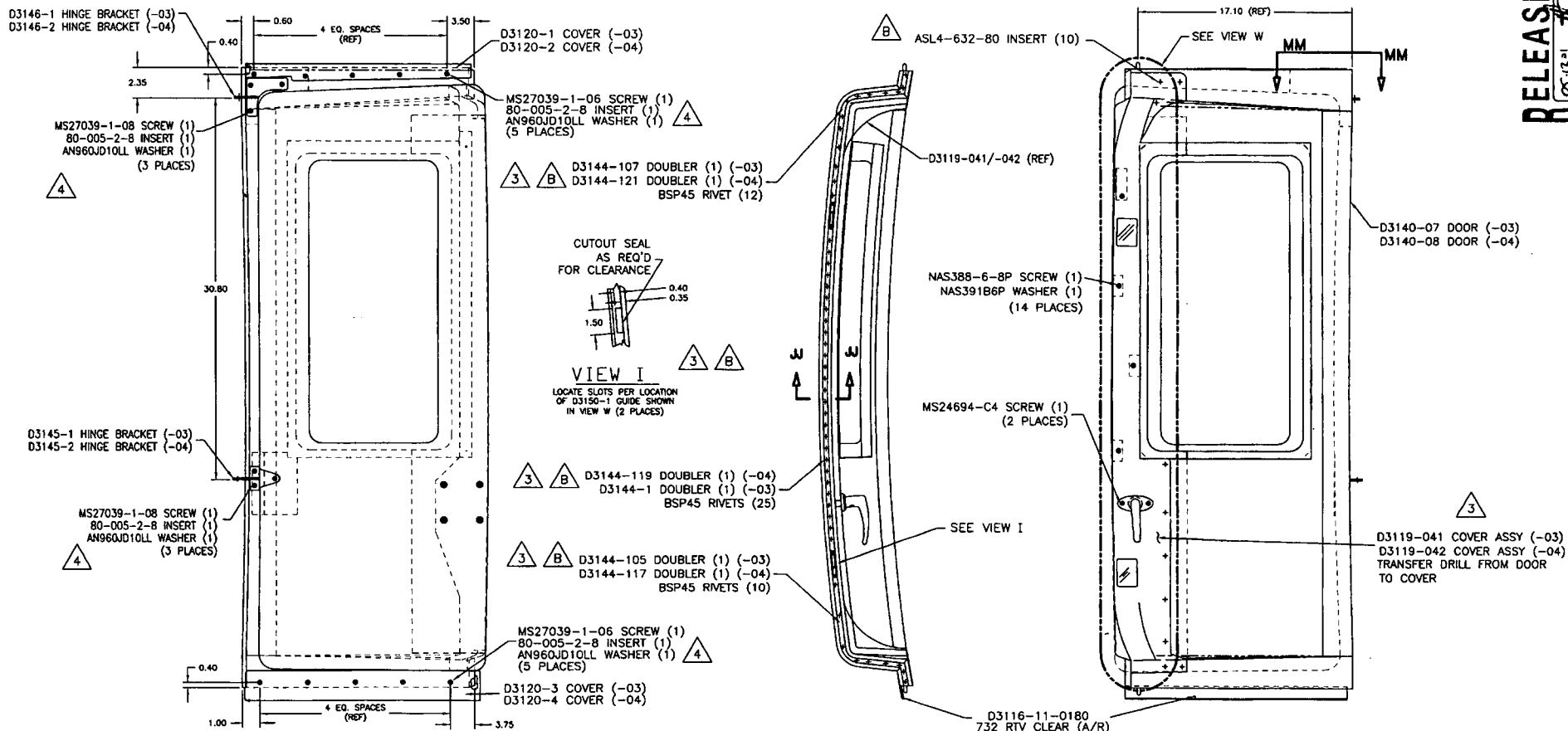
D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)
 VIEW LOOKING @ INSIDE OF DOOR

VIEW Z-Z
OUTER DOOR HANDLE INSTALLATION



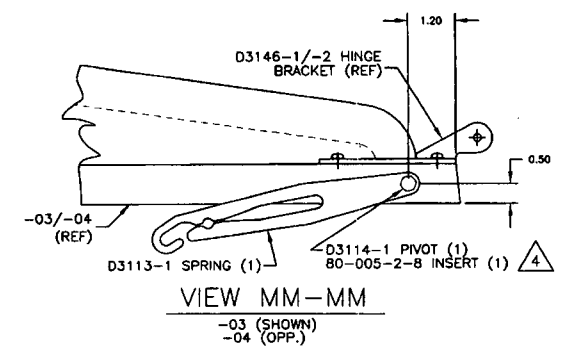
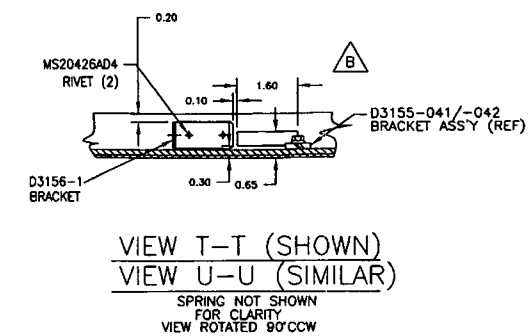
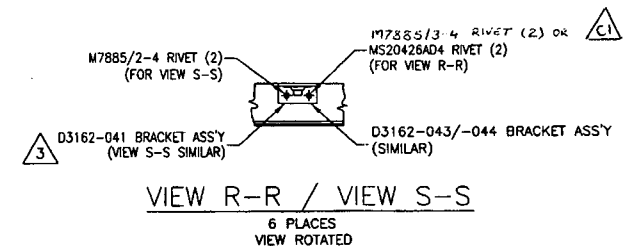
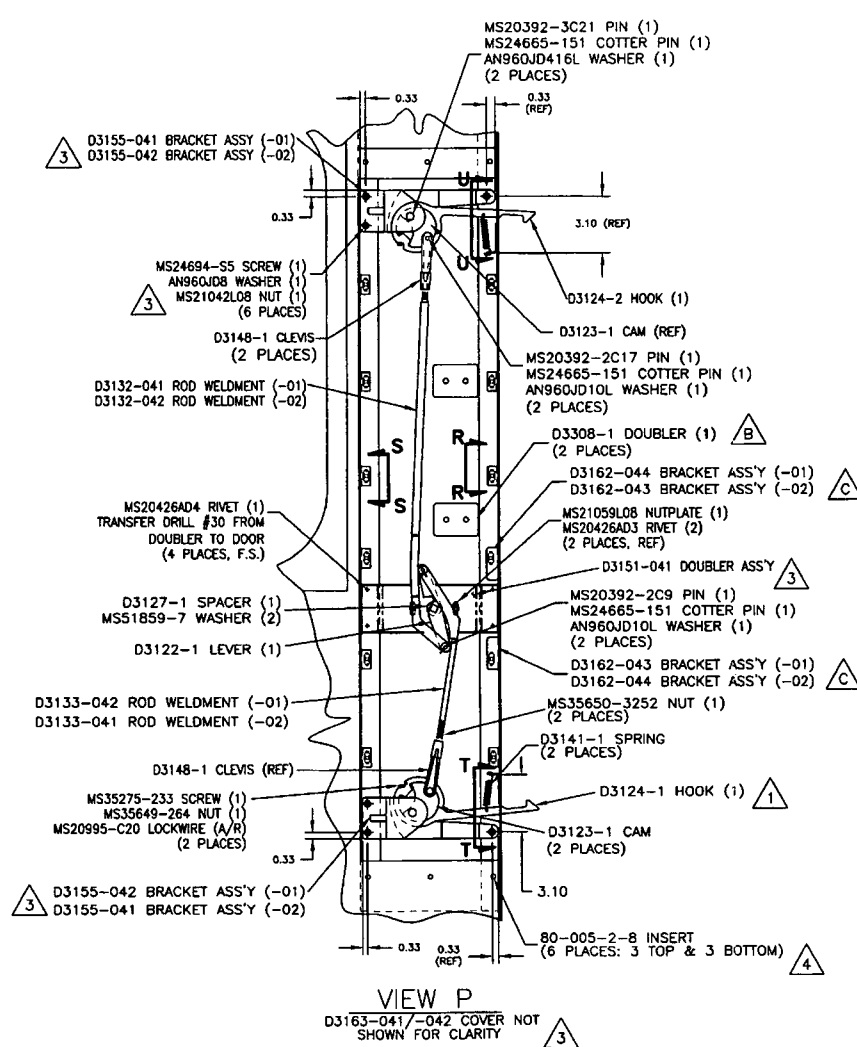
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		DATE	05.11.23			D412-694	SHEET 2 OF 6
						DOOR ASSEMBLY	SCALE NTS

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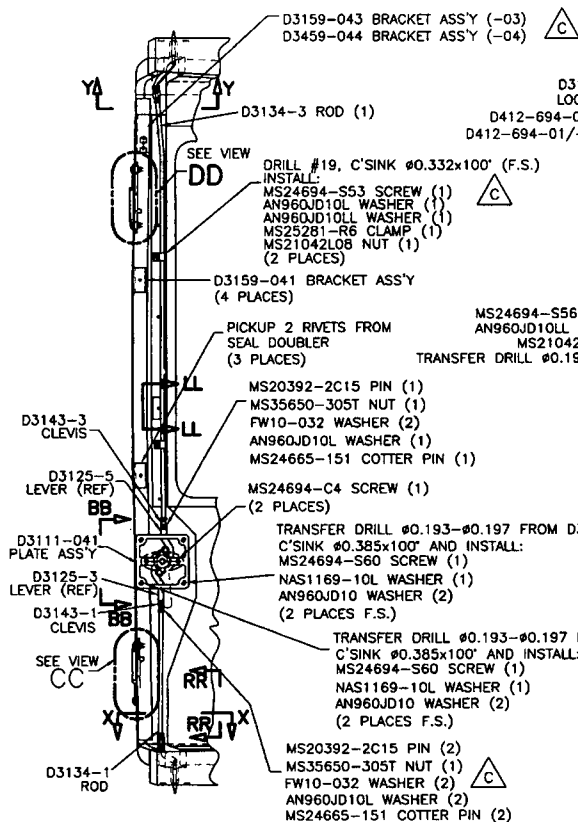
D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)

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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	



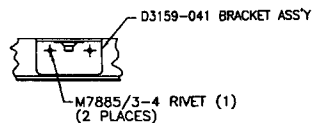
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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	



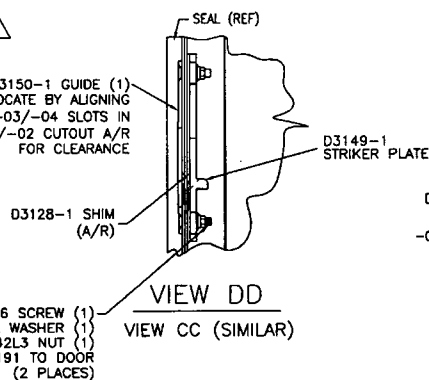
VIEW W

D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY
SEAL ALSO NOT SHOWN FOR CLARITY

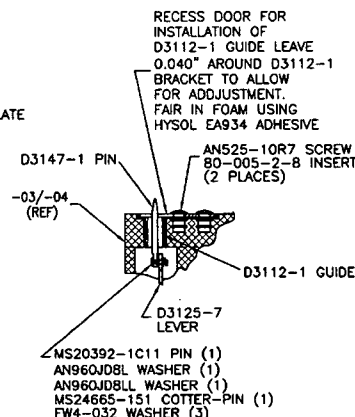


SECTION LL-LL

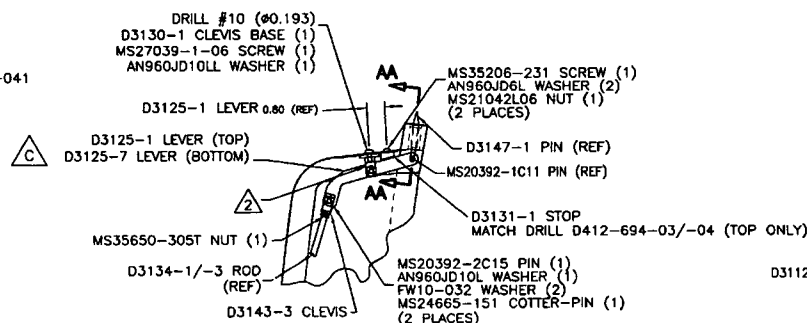
(3 PLACES)
VIEW ROTATED 90°CCW



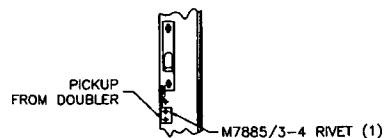
VIEW DD VIEW CC (SIMILAR)



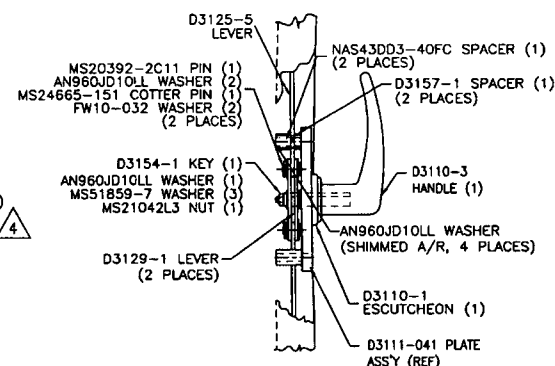
SECTION AA-AA



SECTION FF-FF

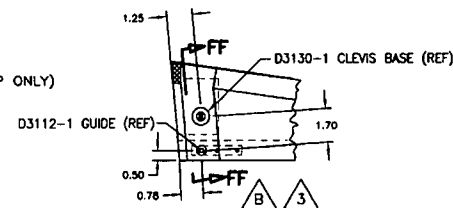


VIEW RR-RR



SECTION BB-BB

VIEW SHOWN WITH MECHANISM IN THE UNLOCKED POSITION FOR CLARITY



SECTION X-X (SHOWN)

SECTION Y-Y (SIMILAR)

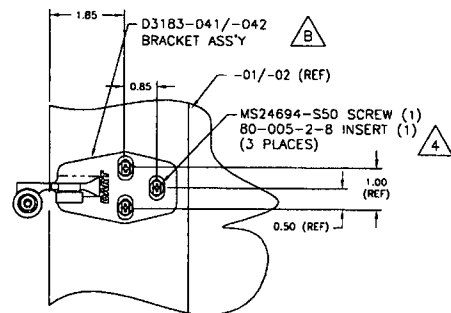
D3125-1 LEVER NOT SHOWN FOR CLARITY

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R 05.12.01

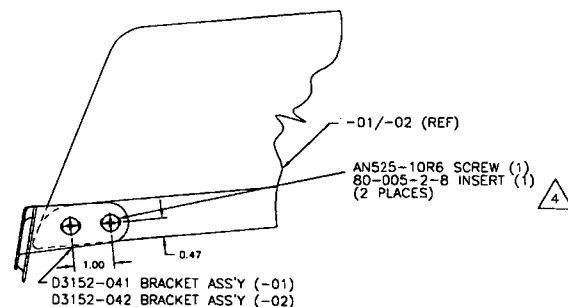
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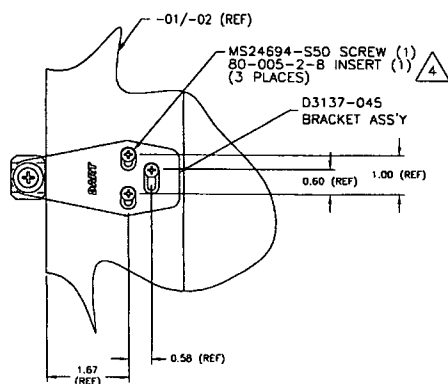
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DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	



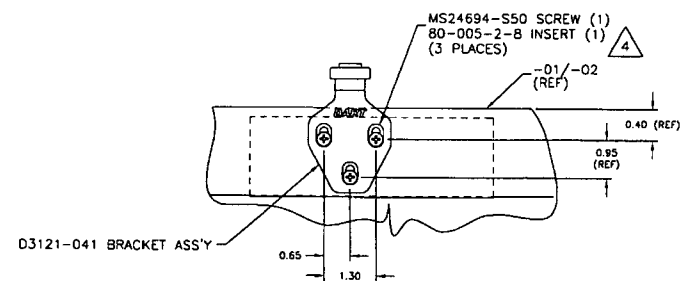
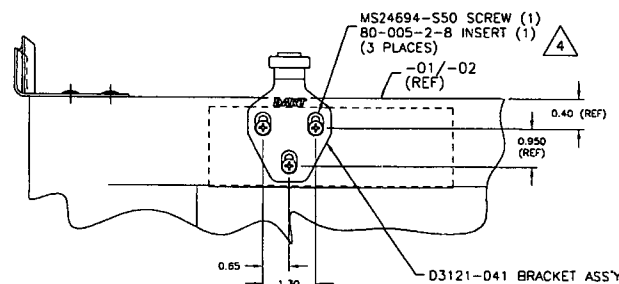
VIEW J



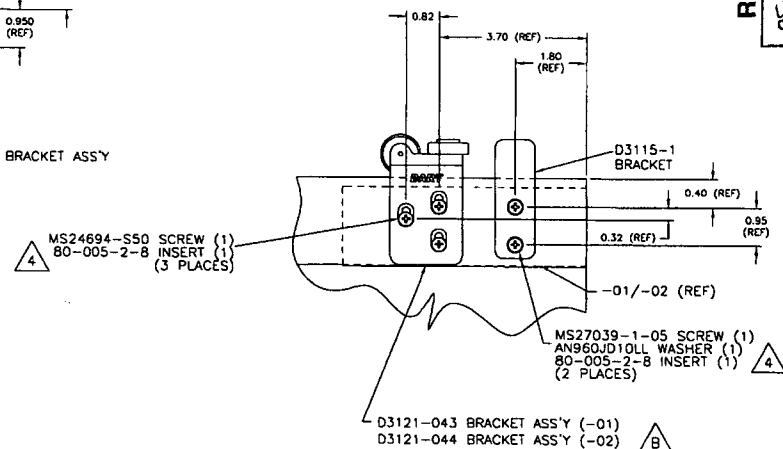
VIEW Q



VIEW H



VIEW L



VIEW M

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-694	REV. C SHEET 6 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 6, 2009 4:15 PM
To: 'Chris Provencal'
Cc: 'Dan Stow'; 'Bill Beckett'; 'Mike Petsche'; 'L Lacelle'
Subject: RE: Devation D412-694-01/-02

Chris,

Considering the timeline on the adhesive and delivery for the door, then I think substituting the ALS4-1032-130 inserts is probably the best thing to do at this point. I would like to see the screws installed with RTV or Proseal or Sikaflex to prevent moisture egress into the door over time. I expect that this cover will come on and off quite frequently as the operator adjusts and inspects the door and would have preferred to see us stick to the potted inserts had time permitted because I believe they have chance of spinning. It would have also been my preference to maintain consistency between doors manufactured by Dart.

Technically, you are correct and we should be doing a DSI to inform the customer that this substitution has been made on his door and that the parts list doesn't match the IIN/ICA. However, the chances of this piece of paper ending up in the hands of the guy who discovers that there is a deviation on these inserts is somewhere between slim and none and so for the effort, I don't think its worth it. You've got better things to do.

My apologies for appearing to be difficult, but from the Ivory Tower here in Calgary, I clearly didn't understand all of the issues and the time constraints involved.

David

PS. Make sure you give Russ a big hug for me ... Sounds like he needs it

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, October 06, 2009 1:25 PM
To: 'David Shepherd'
Cc: 'Dan Stow'
Subject: RE: Devation D412-694-01/-02

According to Chantal, delivery for the hysol is 6-7 weeks.

-Chris

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: October 6, 2009 1:09 PM
To: 'Chris Provencal'
Cc: 'Dan Stow'
Subject: RE: Devation D412-694-01/-02

Structurally, I don't see a problem.
But in terms of commonality between door sets, I would prefer to pot those inserts.
When can we get some more Hysol?

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]

2009-10-06

Sent: Tuesday, October 06, 2009 10:52 AM
To: 'David Shepherd'
Cc: 'Dan Stow'
Subject: Devation D412-694-01/-02

David,

They've run out of potting compound. They want to replace qty(6) 80-005-2-8 INSERTS (potted) with qty(6) ALS4-1032-130 inserts. D412-694 Rev. C, sheet 4, view P: the (6) inserts are located along the top and bottom edge of the cover plate. My main concern would be whether they can install these without damaging the composite, and whether it would hold. However (a) they use similar inserts to attach the floor into the 350 spacepod and (b) they use similar ALS4-632-80 inserts on the D412-694-03/-04 door. I would therefore conclude it is acceptable by comparison. I've attached marked up dwgs for reference.

Is this acceptable? Like the other deviation they need this ASAP!

Sincerely,
Christopher Provencal
DART Aerospace Ltd.

cprovencal@dartaero.com

Tel: (613) 632 5200

Fax: (613) 632 9311

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